US008708015B2

(12) **United States Patent**
Kobayashi

(10) **Patent No.: US 8,708,015 B2**
(45) **Date of Patent: Apr. 29, 2014**

(54) **LABEL MANUFACTURING DEVICE AND LABEL PRINTER**

(75) Inventor: **Kenji Kobayashi**, Tokyo (JP)

(73) Assignee: **Lintec Corporation**, Tokyo (JP)

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

(21) Appl. No.: **13/580,040**

(22) PCT Filed: **Feb. 10, 2011**

(86) PCT No.: **PCT/JP2011/052821**
§ 371 (c)(1),
(2), (4) Date: **Aug. 20, 2012**

(87) PCT Pub. No.: **WO2011/102283**
PCT Pub. Date: **Aug. 25, 2011**

(65) **Prior Publication Data**

US 2012/0318459 A1 Dec. 20, 2012

(30) **Foreign Application Priority Data**

Feb. 22, 2010 (JP) 2010-035941

(51) **Int. Cl.**
B65C 9/46 (2006.01)
B65H 37/00 (2006.01)

(52) **U.S. Cl.**
USPC **156/387**; 156/540

(58) **Field of Classification Search**
USPC 156/230, 234, 247, 249, 289, 384–387, 156/537, 538, 540
See application file for complete search history.

(56) **References Cited**

U.S. PATENT DOCUMENTS

5,707,475	A *	1/1998	Steidinger et al.	156/257
8,025,451	B2 *	9/2011	Yamaguchi et al.	400/613
8,211,826	B2 *	7/2012	Keeton et al.	503/226
8,258,240	B2 *	9/2012	Suzuki et al.	525/228

FOREIGN PATENT DOCUMENTS

JP	B2-7-35104	4/1995
JP	A-7-227924	8/1995
JP	A-10-6564	1/1998
JP	A-2002-1845	1/2002
JP	A-2004-262058	9/2004

OTHER PUBLICATIONS

Sep. 18, 2012 International Preliminary Report on Patentability issued in International Application No. PCT/JP2011/052821.
Jun. 7, 2011 International Search Report issued in International Application No. PCT/JP2011/052821 (with translation).

* cited by examiner

Primary Examiner — Sing P Chan
(74) *Attorney, Agent, or Firm* — Oliff PLC

(57) **ABSTRACT**

A base material sheet is fed from a base material supplying unit by a feeding drive unit. A raw film made up of an adhesive film temporarily attached with a first and release liner and a second release liner is supplied from an adhesive film supplying unit and the second release liner is peeled off from the adhesive film by a peeling unit. A label printer prints on the base material sheet and attaches the adhesive film onto the base material sheet. A label sheet that includes the base material sheet, the adhesive film and the first release liner is supplied to a cutter. After a cut line corresponding to a shape of a label is provided on the base material sheet by the cutter, the base material sheet is further transferred by a guide roller and is wound up by a product winding unit.

5 Claims, 3 Drawing Sheets

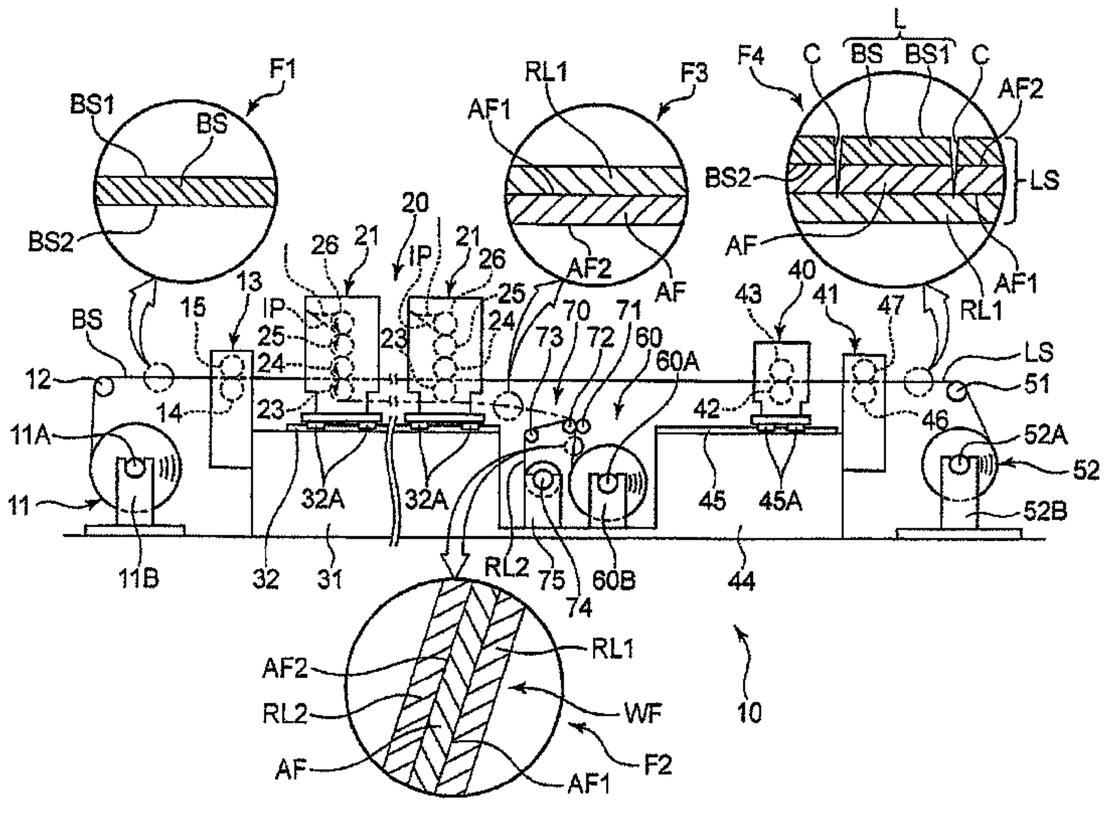


FIG. 1

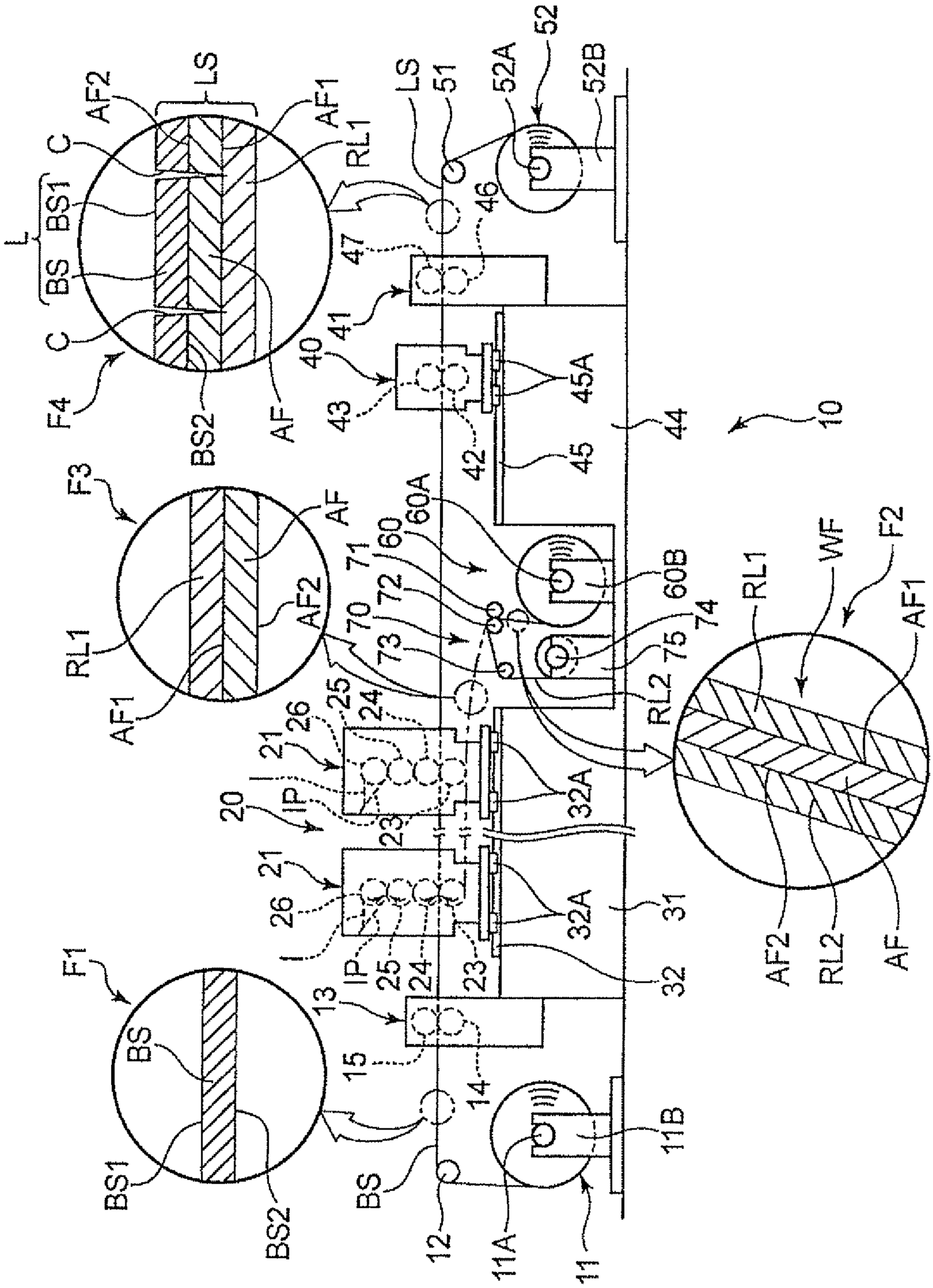

L
BS1
BS
C
AF2
LS
AF1
RL1
F4
BS2
AF
F3
AF1
RL1
AF2
F1
BS1
BS2
BS
AF
LS
51
52A
52
52B
46
47
41
40
43
42
45A
45
44
10
60A
60
71
72
70
73
60B
74
75
RL2
25
24
23
32A
32
31
21
26
20
IP
13
15
14
12
11A
11
11B
RL1
WF
F2
AF1
AF2
RL2
AF

FIG. 2

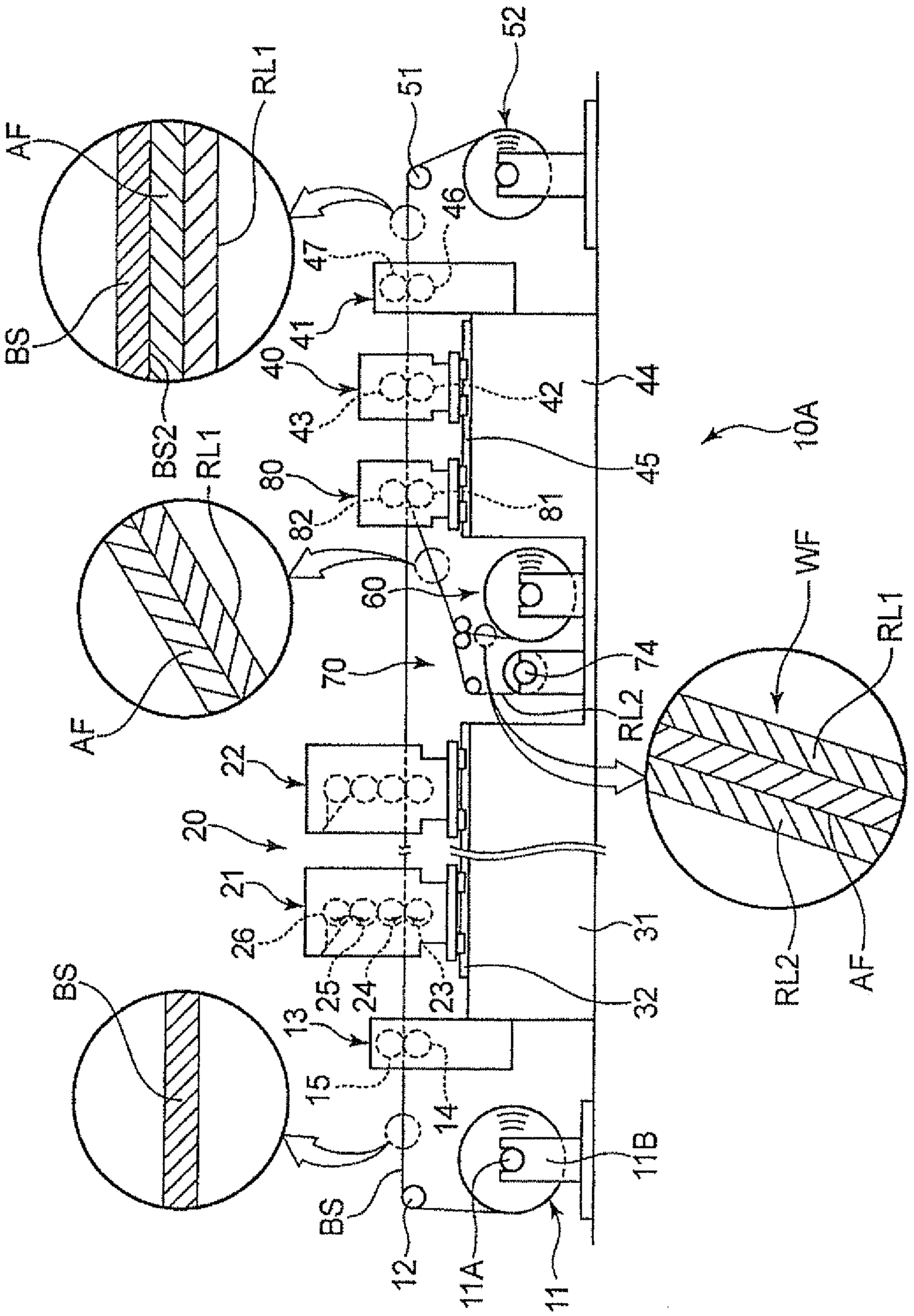
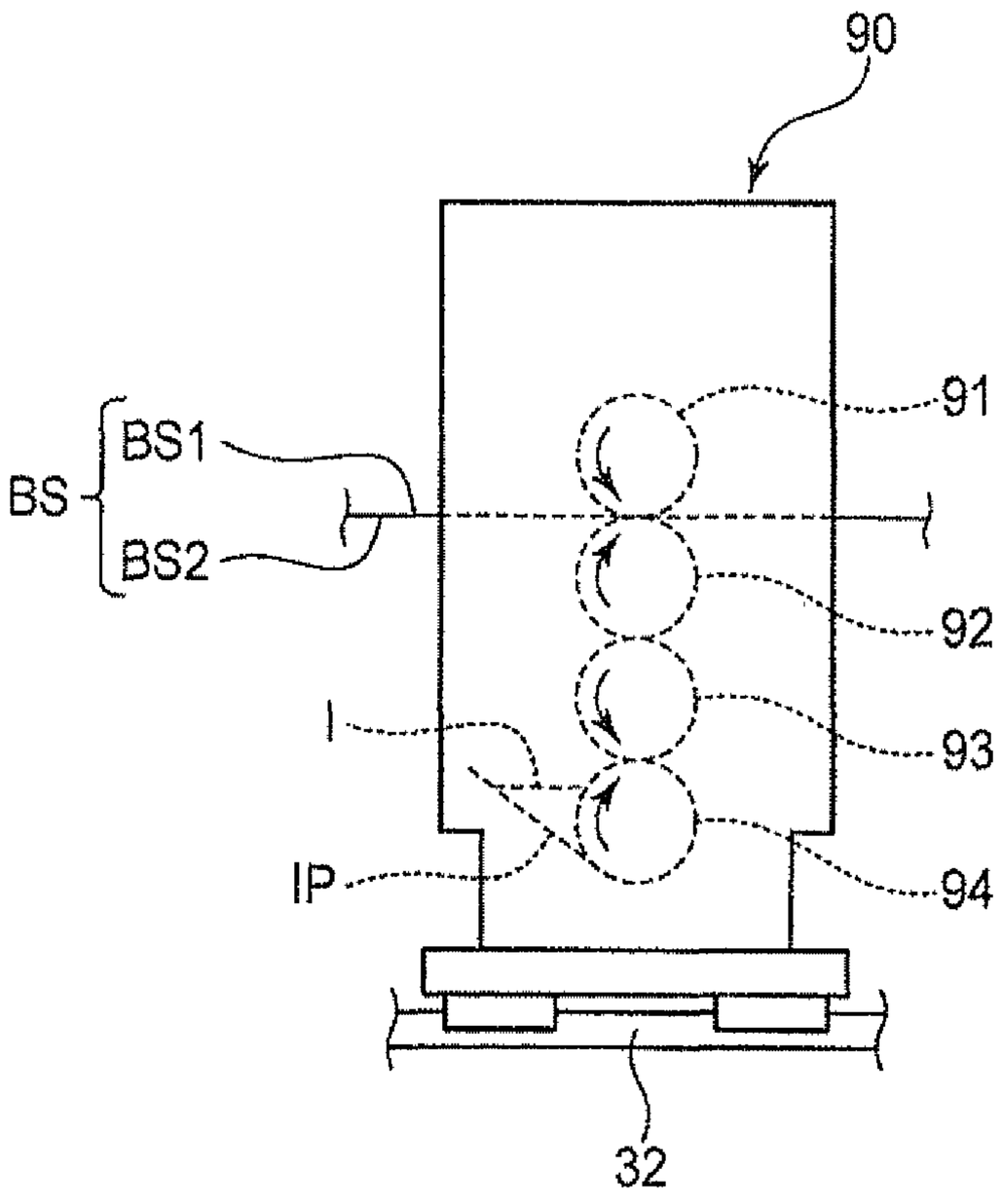

AF
RL1
51
52
46
47
41
40
43
42
44
BS
BS2
RL1
80
82
81
45
10A
60
70
74
RL2
WF
RL1
22
20
21
26
25
24
23
31
32
BS
13
15
14
12
11A
11
11B
RL2
AF

FIG. 3



LABEL MANUFACTURING DEVICE AND LABEL PRINTER

TECHNICAL FIELD

The present invention relates to a label manufacturing device to produce label sheets with a triple layered structure having a base material sheet on which printing is made, an adhesive agent layer and a release liner, as well as a label printer to print on the label sheets with the triple layered structure of the base material sheet, the adhesive agent layer and the release liner.

BACKGROUND ART

Conventionally, a device to print on a base material sheet on which an adhesive agent layer is provided in advance (e.g., Patent Literature 1) and a device to apply an adhesive agent onto a printed base material sheet (e.g., Patent Literature 2) are known as such a label manufacturing device as the above.

CITATION LIST

Patent Literatures

Patent Literature 1: JP-1995-35104B2
Patent Literature 2: JP-A-2002-1845

SUMMARY OF THE INVENTION

Problem(s) to be Solved by the Invention

However, the former of the above two devices requires changes in combinations of types of a base material sheet and an adhesive agent depending on a purpose and intended use because the device prints a web laminated beforehand with an adhesive agent layer on a base material sheet, forcing those in the printing industry offering this type of printing to own a stockpile of webs that matches the number of the combinations. Though the latter is capable of switching base material sheets and adhesive agents, clean-up of an adhesive agent feeding head and the like using solvent is necessary when switching, thus causing workers significant workloads. Another problem is that it takes quite an effort to remove adhesive agent attached on a worker's hands, clothing and peripheral equipment and the like.

An object of the invention is to provide a label manufacturing device and a label printer that allow free combinations of a base material sheet and an adhesive agent used in a label sheet and eliminate workloads in clean-up and removal by workers of adhesive agent when changing base material sheets and adhesive agents.

Means for Solving the Problem(s)

A label manufacturing device according to an aspect of the invention includes: a base material feeder that feeds a belt-shaped base material sheet; a printing unit that prints on a first surface of the base material sheet; a film feeder that feeds a belt-shaped adhesive film that has first and second surfaces both of which are adapted to be adhered, a first release liner being temporarily attached on the first surface of the adhesive film; and an attachment unit that attaches the second surface of the adhesive film onto a second surface of the base material sheet.

The printing unit preferably includes a plate cylinder and an impression cylinder to press the base material sheet onto the plate cylinder, and the impression cylinder serves concurrently as the attachment unit. In other words, the printing unit in the above arrangement does not require a dedicated device for pressure-bonding the base material sheet and the adhesive film because the adhesive film is attached onto the base material sheet while the printing is performed.

The attachment unit may be configured to attach the adhesive film onto the base material sheet after completion of the printing by the printing unit. In other words, in the above configuration, the printing unit and the attachment unit are independent of one another.

A second release liner may be temporarily attached on the second surface of the adhesive film. In this case, the label manufacturing device further includes a peeling unit that peels the second release liner.

The printing unit may be adapted to print on the second surface of the base material sheet.

A label printer according to another aspect of the invention includes: a plate cylinder that holds a plate; and an impression cylinder provided opposed to the plate cylinder, in which the belt-shaped base material sheet and the belt-shaped adhesive film having the first and second surfaces being adapted to be adhered while a first release liner is temporarily attached on the first surface of the adhesive film are sandwiched and transferred by the plate cylinder and the impression cylinder, so that a printing is performed on a first surface of the base material sheet while the second surface of the adhesive film is attached onto a second surface of the base material sheet.

Advantage(s) of the Invention

According to the invention, a base material sheet and adhesive agent used for a label sheet can be freely combined, and workloads in clean-up and removal by workers of adhesive agent and other operations when switching base material sheets and/or adhesive agent can be eliminated.

BRIEF DESCRIPTION OF DRAWING(S)

FIG. **1** schematically shows a configuration of a label manufacturing device according to an exemplary embodiment of the invention.

FIG. **2** schematically shows a configuration of a label manufacturing device according to another exemplary embodiment of the invention.

FIG. **3** is a schematic side view of a printing unit to print on a bottom surface of a base material sheet.

DESCRIPTION OF EMBODIMENT(S)

A label manufacturing device and label printer according to the invention will be described below by reference to exemplary embodiments.

FIG. **1** schematically shows a configuration of a label manufacturing device **10** according to an exemplary embodiment of the invention, which is provided with a label printer **20** (a printing unit).

In summary, the label manufacturing device **10** includes: a base material supplying unit **11** from which a belt-shaped base material sheet BS is pulled up; a guide roller **12** that guides the base material sheet BS toward a feeding drive unit **13**; and the label printer **20** to which the base material sheet BS is supplied. On the other hand, a belt-shaped adhesive film AF that enables adhesion of both sides and is temporarily attached with a first release liner RL**1** on an adhered attachment surface (a first surface) AF**1** (an upper surface in an expanded view F**3** of FIG. **1**) is supplied to the label printer **20**

via a peeling unit **70** (a peeling unit) from an adhesive film supplying unit **60** (a film feeder). The base material sheet BS has a front surface (a first surface) BS**1** (an upper surface in an expanded view F**1** of FIG. **1**) and a back surface (a second surface) BS**2** (a lower surface in the expanded view F**1** of FIG. **1**). In the label printer **20**, printing is made on the front surface BS**1**, and a base material attachment surface (a second surface of the adhesive film AF) AF**2** (a lower surface in the expanded view F**3** of FIG. **1**) is attached onto the back surface BS**2** to provide a label sheet LS (see an expanded view F**4** of FIG. **1**) made up of the base material sheet BS, the adhesive film AF and the first release liner RL**1**. The label sheet LS is then conveyed to a cutter **40**, where a cut line C is formed that extends from the first surface of the base material sheet BS into the first release liner RL**1**. Afterwards, the label sheet LS is transferred by a winding drive unit **41** and is guided toward a product winding unit **52** by a guide roller **51** to be wound up. Incidentally, the base material supplying unit **11**, the feeding drive unit **13**, the winding drive unit **41** and the product winding unit **52** constitute a base material feeder.

Details of a configuration of the label manufacturing device will be provided below.

The base material supplying unit **11** is provided with a support roller **11**A to support the base material sheet BS that is wound in a roll, as well as a support bracket **11**B to support the support roller **11**A in a rotatable manner. The base material sheet BS may be constructed of, for instance, one or multiple layers of a belt-shaped sheet made of paper or resin.

The feeding drive unit **13** is installed between a guide roller **12** and the label printer **20**. The feeding drive unit **13** is provided with a drive roller **14** that is positioned on a side of the back surface BS**2** of the base material sheet BS and is connected to a motor (not shown), as well as a driven roller **15** that is positioned on a side of the front surface BS**1** of the base material sheet BS and rotates in conjunction with the drive roller **14** via an interlocking member such as a timing belt (not shown).

The label printer **20** may include the number of printing units in accordance with usage. In normal color printing, four printing units **21** are arranged in order along a direction of transferring the base material sheet BS to print in four colors of black, cyan, magenta and yellow (two of the printing units **21** not shown in FIG. **1**). The printing unit **21** includes: an impression cylinder **23** that is positioned on a side of the back surface BS**2** of the base material sheet BS; a plate cylinder **24** that is positioned on a side of the front surface BS**1** of the base material sheet BS; ink supply rollers **25** and **26** that are located on an upper side of the plate cylinder **24**; and an ink pan IP that abuts the ink supply roller **26**. The printing unit **21** is supported in a manner capable of displacement along the direction of transferring the base material sheet BS via a rail **32** and a slider **32**A provided on a base **31**. The impression cylinder **23** is connected to an output shaft of a motor (not shown) for rotation. The plate cylinder **24** and the ink supply rollers **25** and **26** rotate in conjunction with the impression cylinder **23** via the interlocking member such as a timing belt (not shown) The plate cylinder **24** is adapted to hold a plate on which content to be printed on the base material sheet BS is formed (not shown). Ink I that is stored in the ink pan IP is supplied to the plate via the ink supply rollers **25** and **26**, so that the content is printed on the front surface BS**1** of the base material sheet BS. The height position of the impression cylinder **23** can be adjusted in an up-down direction in FIG. **1** by a position adjuster (not shown). The impression cylinder **23** is thereby appropriately spaced away from the plate cylinder **24** depending on a thickness of the base material sheet BS and the like, so that the impression cylinder **23** is pressed on the base material sheet BS with adequate force. By rotating the impression cylinder **23** and the plate cylinder **24** in conjunction with the base material feeder, the base material sheet BS that is transferred between the two cylinders is printed. Since other printing units **21** have the same configuration, description of the other printing units **21** is omitted.

The adhesive film supplying unit **60** is arranged between the label printer **20** and the cutter **40**. The adhesive film supplying unit **60** includes: a support roller **60**A that supports the adhesive film AF wound up in a roll; and a support bracket **60**B that supports the support roller **60**A in a rotatable manner. Incidentally, the adhesive film AF is supported by the support roller **60**A and is a form of a raw film WF having a triple-layered structure in which the first release liner RL**1** is temporarily attached to the adhered attachment surface AF**1** and a second release liner RL**2** is temporarily attached to the base material attachment surface AF**2**, as shown in an expanded view F**2** in FIG. **1**.

A peeling unit **70** includes: a drive roller **71** that rotates in conjunction with an output shaft of a motor (not shown); a peeling roller **72** that sandwiches the raw film WF with the drive roller **71** and peels the second release liner RL**2**; a winding roller **74** that rotates in conjunction with an output shaft of a motor (not shown) and winds up the second release liner RL**2** that is partially wound around a guide roller **73**; and a support bracket **75** that supports the winding roller **74** in a rotatable manner. Thus, the second release liner RL**2** is peeled by the peeling roller **72** from the raw film WF fed from the adhesive film supplying unit **60**. The belt-shaped adhesive film AF that is temporarily attached with the first release liner RL**1** is then supplied to the label printer **20**.

The adhesive film AF temporarily attached with the first release liner RL**1** is partially wound on the impression cylinder **23** of the printing unit **21** on a right side (downstream-most side) of FIG. **1**, where the base material attachment surface AF**2** of the adhesive film AF is attached to the back surface BS**2** of the base material sheet BS, so that the label sheet LS having a triple-layered structure in which the printed base material sheet BS, the adhesive film AF and the first release liner RL**1** are laminated in this order from above is formed as shown in the expanded view F**4** of FIG. **1**. Incidentally, the printing unit **21** in which the adhesive film AF and the first release liner RL**1** are partially wound on the impression cylinder **23** may not be the most downstream printing unit **21**, but may be other one of printing unit **21** (e.g. the most upstream printing unit **21**).

The cutter **40** includes: a platen roller **42** that is positioned on a side of the first release liner RL**1** of the label sheet LS and is connected to a motor (not shown); and a die cutting roller **43** that is positioned on a side of the base material sheet BS of the label sheet LS and rotates in conjunction with the platen roller **42** via an interlocking member such as a timing belt (not shown). The cutter **40** is supported in a fashion that enables displacement along a direction of transferring the label sheet LS via a rail **45** and a slider **45**A thereof provided on a base **44**. The base material sheet BS and the adhesive film AF are provided with the cut line C that is made by the die cutting roller **43** corresponding to a predetermined label shape, so that the base material sheet BS and the adhesive film AF can be peeled off from the first release liner RL**1**.

The winding drive unit **41** includes: a drive roller **46** that is positioned on a side of the first release liner RL**1** of the label sheet LS and is connected to a motor (not shown); and a driven roller **47** that is positioned on a side of the base material sheet BS of the label sheet LS and rotates in conjunction with the drive roller **46** via an interlocking member such as a timing belt (not shown).

The product winding unit **52** includes: a winding roller **52**A that rotates in conjunction with an output shaft of a motor (not shown) and winds up the label sheet LS guided by a guide roller **51**; and a support bracket **52**B that rotatably supports the winding roller **52**A.

As discussed above, in the label manufacturing device **10** in the exemplary embodiment of the invention, the adhesive film AF can be attached to the base material sheet BS by using the raw film WF that includes the first and second release liners RL**1** and RL**2** temporarily attached onto both surfaces of the sheet-shaped adhesive film AF and peeling the second release liner RL**2** from the adhesive film AF. Accordingly, since the base material sheet BS and the adhesive film AF can be combined simultaneously with printing on the base material sheet BS, those in the printing industry are not required to keep the number of label sheets LS in stock that corresponds to the number of combinations made depending on a purpose and usage. When switching adhesive agents provided on a label, all required work is to select the raw film WF that is provided with the adhesive film AF made of a desired adhesive agent. Further, in changing adhesive agents, all required work is to place the predetermined raw film WF in the adhesive film supplying unit **60**, thus removing burdens of clean-up, removal of adhesive agent and the like conventionally performed by workers.

In the present exemplary embodiment, the label printer **20** is configured to sandwich the base material sheet BS, the adhesive film AF and the first release liner RL**1** by the impression cylinder **23** and the plate cylinder **24** and print on the base material sheet BS while attaching the adhesive film AF to the base material sheet BS by a biasing force generated by the sandwiching. In other words, the impression cylinder **23** of the label printer **20** serves concurrently as an attachment unit, thus eliminating a need to provide a dedicated attachment unit for pressure bonding the adhesive film AF and the base material sheet BS.

FIG. **2** schematically shows a configuration of a label manufacturing device **10**A according to another exemplary embodiment of the invention. The label manufacturing device **10**A differs from the label manufacturing device **10** shown in FIG. **1** in that the label printer **20** of the label manufacturing device **10**A only prints on the base material sheet BS and does not function concurrently as an attachment unit to attach the adhesive film AF to the base material sheet BS and that a pressing machine **80** to attach the adhesive film AF temporarily attached with the first release liner RL**1** to the base material sheet BS is provided. Other configurations are the same as in the exemplary embodiment in FIG. **1**.

The pressing machine **80** includes: a drive roller **81** that is connected to a motor (not shown); and a driven roller **82** that rotates in conjunction with the drive roller **81** via an interlocking member such as a timing belt (not shown). The pressing machine **80** is supported in a manner displaceable along the transfer direction of the label sheet LS via the rail **45** provided on the base **44**. A distance between the drive roller **81** and the driven roller **82** can be adjusted by a position adjuster (not shown), so that a pressure-bonding force suitable for a thickness of the base material sheet BS, the adhesive film AF and the like can be obtained.

As discussed above, in the label manufacturing device **10**A, an attachment unit to attach the adhesive film AF to the base material sheet BS attaches the adhesive film AF to the base material sheet BS after completion of printing by the label printer **20**. Thus, the label manufacturing device **10**A provides the same advantage as the label manufacturing device **10**. Moreover, since the label printer **20** of the label manufacturing device **10**A does not attach the adhesive film AF to the base material sheet BS, it has more leeway in arrangements of each printing unit (e.g. freedom is given in arrangements of a printing unit **90** (described below) for printing bottom surfaces and the like).

In the above two exemplary embodiments, the label manufacturing device is configured in a way that printing is conducted on the front surface BS**1** of the base material sheet BS. However, a printing unit for printing on the back surface BS**2** of the base material sheet BS may be further provided. FIG. **3** schematically shows a configuration of the printing unit **90** for printing on back surfaces. The printing unit **90** includes: an impression cylinder **91** that is positioned on a side of the front surface BS**1** of the base material sheet BS; a plate cylinder **92** that is positioned on a side of the back surface BS**2** of the base material sheet BS; ink supply rollers **93** and **94** that are located under the plate cylinder **92**; and an ink pan IP that abuts the ink supply roller **94**. The printing unit **90** is supported in a manner displaceable along the transfer direction of the base material sheet BS via the rail **32** and the slider **32**A thereof provided on the base **31**. The impression cylinder **91** rotates by being connected to an output shaft of a motor (not shown). The plate cylinder **92** and the ink supply rollers **93** and **94** rotate in conjunction with the impression cylinder **91** via an interlocking member such as a timing belt (not shown) The plate cylinder **92** is adapted to hold a plate on which content to be printed on the base material sheet BS is formed (not shown). Ink I that is stored in the ink pan IP is supplied to the plate via the ink supply rollers **93** and **94**, so that the content is printed on the back surface BS**2** of the base material sheet BS. The printing unit **90** for printing on bottom surfaces can be arranged at a given position in the label printer **20**. According to the configuration in FIG. **1**, the printing unit **90** is provided upstream on a transferring path of the base material sheet BS, compared to the printing unit **21** having the impression cylinder **23** on which the adhesive film AF and the first release liner RL**1** are wound.

Incidentally, the adhesive film AF is not limited to the configurations described in the above exemplary embodiments. For instance, the adhesive film AF may be provided by a sheet-shaped core applied with an adhesive agent on both surfaces thereof. When the adhesive film has a core as described above, adhesive agent layers having different natures on both sides of the core can be provided, so that gaps in bonding strength between the front and back surfaces of the adhesive film can be provided and the adhesive film can be used for a label sheet that has a release liner attached only on one surface thereof.

The invention claimed is:

1. A label manufacturing device comprising:

a base material feeder that feeds a belt-shaped base material sheet;

a printing unit that prints on a first surface of the base material sheet;

a film feeder that feeds a belt-shaped adhesive film that has first and second surfaces both of which are adapted to be adhered, a first release liner being temporarily attached on the first surface of the adhesive film; and

an attachment unit that attaches the second surface of the adhesive film onto a second surface of the base material sheet, wherein the printing unit comprises a plate cylinder and an impression cylinder to press the base material sheet onto the plate cylinder, the impression cylinder serving concurrently as the attachment unit and the printing being performed while the adhesive film is attached onto the base material sheet.

2. The label manufacturing device according to claim 1, wherein the attachment unit attaches the adhesive film onto the base material sheet after completion of the printing by the printing unit.

3. The label manufacturing device according to claim 1, wherein a second release liner is temporarily attached on the second surface of the adhesive film and the label manufacturing device further comprises a peeling unit that peels the second release liner.

4. The label manufacturing device according to claim 1, wherein the printing unit is adapted to print on the second surface of the base material sheet.

5. A label printer comprising:

a plate cylinder that holds a plate; and

an impression cylinder provided opposed to the plate cylinder,

wherein a belt-shaped base material sheet and a belt-shaped adhesive film are sandwiched and transferred by the plate cylinder and the impression cylinder, the adhesive film having first and second surfaces being adapted to be adhered, a first release liner being temporarily attached on the first surface of the adhesive film, so that a printing is performed on a first surface of the base material sheet while the second surface of the adhesive film is attached onto a second surface of the base material sheet.

* * * * *